

82563

Work Order ID 59765

Thursday, June 10, 2010 2:45:52 PM



Page 1

Item ID: D205-633-011

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step

Stop



Start Date: 6/10/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/25/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-6-10 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
N/A	Rev N/A

100



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

0.00

Photocopy bluefile & type labels per PPP205-633-011 CHG001

8/10/06/25

HG for CL 10/06/24

110



Pick Kit

0.00

Packaging

Packaging

Memo

0.00

C04/06/25 (6)

120



QC4- 100% Inspect kits for completeness

0.00

QC

Quality Control

Memo

0.00

8/10/06/25

(HG) _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59765

Thursday, June 10, 2010 2:45:52 PM



Page 2

Item ID: D205-633-011

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step

Stop



Start Date: 6/10/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/25/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

130



Packaging

Packaging

Operation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

Rev 4

10.6.25 SP/ax

140 QC21- Final Inspection - Work Order Release

0.00

140



QC

Quality Control

Memo

0.00

10.6.25

10.6.25

10.6.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 10, 2010 2:45:57 PM

Page 1

Work Order ID: 59765



Parent Item: D205-633-011



Parent Item Name: Heli-Access-Step

Start Date: 6/10/2010

Required Date: 6/25/2010

Comments: IPP Rev:F□02.07.11□Reformat; Removed D3010 □RF□

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-14A S Bolt		Purchased	No		110	Each	360.0000	1	6				
----------------------	--	-----------	----	--	-----	------	----------	---	---	--	--	--	--

Location

ST357	344	
114582	44	
114752	300	
ST358	16	
113359	16	

Loc Qty

Loc Qty

Loc Code

114752

AN4-5A S Bolt		Purchased	No		110	Each	230.0000	2	12				
---------------------	--	-----------	----	--	-----	------	----------	---	----	--	--	--	--

Location

ST356	230	
114108	30	
114330	200	

Loc Qty

Loc Qty

Loc Code

114108

AN4-6A S Bolt		Purchased	No		110	Each	773.0000	2	12				
---------------------	--	-----------	----	--	-----	------	----------	---	----	--	--	--	--

Location

ST356	773	
112933	96	
113149	600	
114523	2	
114615	75	

Loc Qty

Loc Qty

Loc Code

1113149

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 10, 2010 2:45:57 PM

Page 2 /6

Work Order ID: 59765



Parent Item: D205-633-011



Parent Item Name: Heli-Access-Step

Start Date: 6/10/2010

Required Date: 6/25/2010

Comments: IPP Rev:F □ 02.07.11 □ Reformat; Removed D3010 □ RFP □

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---	--------------------------------	-----------------------	---------------------	-----------------------------	--------------------------	-------------------------	----------------------------	------------------------	--------------------	----------------------	-----------------------	------------------------	---------------

AN4-7A 		Purchased	No		110	Each	194.0000	2	112 				
------------	--	-----------	----	--	-----	------	----------	---	---------	--	--	--	--

S tb Bolt

Location Loc Qty Loc Code

ST356 194

113226 194

110 Each

70.0000

1

AN5-14A 		Purchased	No		110	Each	70.0000	1 				
-------------	--	-----------	----	--	-----	------	---------	-------	--	--	--	--

S tb Bolt

Location Loc Qty Loc Code

ST338 70

112411 20

112489 50

110 Each

46.0000

1

AN5-6A 		Purchased	No		110	Each	46.0000	1 				
------------	--	-----------	----	--	-----	------	---------	-------	--	--	--	--

S tb Bolt

Location Loc Qty Loc Code

ST337 46

112243 46

110 Each

18.0000

15

AN960JD416 	NAS1149D0463J	Purchased	No		110	Each	18.0000	15 				
----------------	---------------	-----------	----	--	-----	------	---------	--------	--	--	--	--

F Washer

Location Loc Qty Loc Code

ST357 18

107939 18

110 Each

0.0000

4

AN960JD516 	NAS1149D0563J	Purchased	No		110	Each	0.0000	4 				
----------------	---------------	-----------	----	--	-----	------	--------	-------	--	--	--	--

F Washer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 10, 2010 2:45:57 PM

Page 3 /6

Work Order ID: 59765



Parent Item: D205-633-011



Parent Item Name: Heli-Access-Step

Start Date: 6/10/2010

Required Date: 6/25/2010

Comments: IPP Rev:F02.07.11Reformat; Removed D3010 RF

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2021-101 Eyebolt		Manufactured	No		110	Each	15.0000	1		6			
--------------------------	--	--------------	----	--	-----	------	---------	---	--	---	--	--	--

Location

ST004 15

59159 15

110 Each 200.0000 2

59159

12

Location

ST504 200

50746 100

52325 100

110 Each 118.0000 2

50746

12

Location

ST004 118

47964 118

110 Each 4.0000 1

47964

16

1/10/10 1/10/10
B601062X P0146/24(6)

Location

ST264 4

59217 4

110 Each 0.0000 1

59217

6

59064 1/10/20
S40

D2563 Step Weldment Assembly		Manufactured	No		110	Each	0.0000	1					
-------------------------------------	--	--------------	----	--	-----	------	--------	---	--	--	--	--	--

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 10, 2010 2:45:57 PM

Page 4 /6

Work Order ID: 59765



Parent Item: D205-633-011



Parent Item Name: Heli-Access-Step

Start Date: 6/10/2010

Required Date: 6/25/2010

Comments: IPP Rev:F002.07.11 Reformat; Removed D3010 RFO

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total .Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	---------------	----------------	--------

D2565-101 S tb Strut		Manufactured	No		110		Each	5.0000	1	6	596811X C	
----------------------------	--	--------------	----	--	-----	--	------	--------	---	---	-----------	--

Location Loc Qty Loc Code

ST270 5

59218 5

D2565-103 S tb Strut		Manufactured	No		110		Each	7.0000	1	6	59218 5X C	
----------------------------	--	--------------	----	--	-----	--	------	--------	---	---	------------	--

Location Loc Qty Loc Code

ST270 7

59219 7

D2565-105 S tb Strut		Manufactured	No		110		Each	7.0000	1	6	59219 C	
----------------------------	--	--------------	----	--	-----	--	------	--------	---	---	---------	--

Location Loc Qty Loc Code

ST270 7

59220 7

D2565-107 S tb Strut		Manufactured	No		110		Each	5.0000	1	6	59220 596811X C14C24(6)	
----------------------------	--	--------------	----	--	-----	--	------	--------	---	---	-------------------------	--

Location Loc Qty Loc Code

ST270 5

59221 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 10, 2010 2:45:57 PM

Page 5 / 6

Work Order ID: 59765



Parent Item: D205-633-011



Parent Item Name: Heli-Access-Step

Start Date: 6/10/2010

Required Date: 6/25/2010

Comments: IPP Rev:F□02.07.11□Reformat; Removed D3010 □RF□

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2565-109 	Strut	Manufactured	No		110	Each	5.0000	1	6 ✓			59683 10	
---------------	-------	--------------	----	--	-----	------	--------	---	-----	--	--	----------	--

Location

ST270 5

59222 5

110 Each 5.0000

Location

ST270 5

59223 5

110 Each 3,820.000

Location

ST139 2

111827 2

ST300 3818

113422 68

114523 742

114718 1000

114784 2000

9063 8

MS21042L4



Nut

Purchased No

59223 50

48

10/6/2010 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 10, 2010 2:45:57 PM

Page 6

16

Work Order ID: 59765



Parent Item: D205-633-011



Parent Item Name: Heli-Access-Step

Start Date: 6/10/2010

Required Date: 6/25/2010

Comments: IPP Rev:F□02.07.11□Reformat; Removed D3010□RF□

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21042L5 S Nut		Purchased		No		110	Each	726.0000	2	12			

Location	Loc Qty	Loc Code
ST139	500	
114813	500	
ST300	226	
114449	226	114449

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY**5.0 PARTS LISTS****5.1 D205-633-011/-013/-015/-017 Heli-Access Step**

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				D205-633-011	<i>Heli-Access-Step™, High Gear</i>
	X			D205-633-013	<i>Heli-Access-Step™, Extended High Gear (31")</i>
		X		D205-633-015	<i>Heli-Access-Step™, Extended High Gear (39")</i>
			X	D205-633-017	<i>Heli-Access-Step™, Standard Low Gear</i>
1			1	D2021-101	EYEBOLT
2	2	2	2	D2022-101	SPACER
2	2	2	2	D2022-103	SPACER
1				D2562-001	STRUT
		1		D2562-005	STRUT
			1	D2562-007	STRUT
			1	D2562-013	STRUT
1	1	1	1	D2563	WELDMENT ASSEMBLY
1				D2565-101	STRUT
1				D2565-103	STRUT
1				D2565-105	STRUT
1				D2565-107	STRUT
1				D2565-109	STRUT
1				D2565-111	STRUT
	1			D2565-201	STRUT
	1			D2565-203	STRUT
	1			D2565-205	STRUT
	1			D2565-207	STRUT
	1			D2565-209	STRUT
	1			D2565-211	STRUT
		1		D2565-301	STRUT
		1		D2565-303	STRUT
		1		D2565-305	STRUT
		1		D2565-307	STRUT
		1		D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-4C7	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
			1	D3165-1	SUPPORT ARM
		1	1	AN44-7A	EYEBOLT
2	1	1	2	AN4-5A	BOLT
2	3	3	2	AN4-6A	BOLT
2	2	2	2	AN4-7A	BOLT
1	1	1	1	AN4-14A	BOLT
1	1	1		AN4-10A	BOLT
1			1	AN5-6A	BOLT
1	1	1	1	AN5-14A	BOLT
15	16	16	15	AN960JD416	WASHER
.4	4	4	4	AN960JD516	WASHER
8	8	8	8	MS21042L4	NUT (or MS21042-4)
2	2	2	2	MS21042L5	NUT (or MS21042-5)

©COPYRIGHT © 2002 BY DART AEROSPACE LTD. •
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
 OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: B
 Date: 07/08/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries